

Date: Tuesday, 12/20/2005 9:44:55 AM  
User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206B BASKET BASE					
Job Number	: 22087B									
Estimate Number	: 11276									
P.O. Number	: N/A			Part Number	: D2330041					
This Issue	: 12/20/2005 S.O. No. : N/A			Drawing Number	: UNDER REVIEW					
Prsht Rev.	: NC			Project Number	: N/A					
First Issue	: N/A			Drawing Revision	: E					
Previous Run	:			Material	: N/A					
Written By	<u>SEE COMMENT BELOW</u>			Due Date	: 1/30/2006					
Checked & Approved By	<u>SEE ABOVE USER &amp; DATE</u>			Qty:	1 Um: Each					
Comment	: Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J									
<b>Additional Product</b>										
Job Number:										
Seq. #:	Machine Or Operation:			Description :						
1.0	D31661			Basket Hoop						
										
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)									
	Pick: 4									
	Qty	Part#	Description	Batch	Babas9 (2) B25849 (2) PD					
	4	D3166-1	Hoop		06-04-05					
2.0	M304TS0750W065			304 SQ Tube.75x.75x.065W						
										
	Comment: Qty.: 25.3019 f(s)/Unit Total : 25.3019 f(s)									
	3/4" x 3/4" x 0.063 wall 304/316 SS tubing.			Batch: M100S60 PD 06-04-05						
3.0	LARGE FAB 1			LARGE FABRICATION RESOURCE 1						
										
	Comment: LARGE FABRICATION RESOURCE 1									
	1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.									
	Cut 4 D2235-1 From D3166-1									
	2- Cut D2330-1-3-5-7-9 as per Dwg D2330									
	3-Drill hole in D2330-3 as per Dwg D2330									
	4-Deburr			PD 06-04-05						
4.0	D22531			Lug						
										
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)									
	Pick:									
	Qty	Part Number	Description	Batch						
	2	D2253	Gusset	B12413	PD 06-04-05					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 9:44:56 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE

Job Number: 22087B

Part Number: D2330041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2012-107 Clevis

~~6-26-05~~ B25483

PD

06-04-05

6.0 D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-3 Bushing

~~6-26-05~~ B25483

PD

06-04-05

7.0 D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2581 Mounting Chanel

~~6-26-05~~ B25834(3) B26204 (1) PD

06-04-05

8.0 D2254

Gusset for D206bskt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2254 Lug

~~6-26-05~~ B23421

PD

06-04-05

9.0 D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3 HINGE

~~6-26-05~~ B25239

PD

06-04-05

10.0 D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2012-107 CLEVIS

~~6-26-05~~ B25483

PD

06-04-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/04/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Tuesday, 12/20/2005 9:44:56 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE

Job Number: 22087B

Part Number: D2330041

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 31.5000 sf(s)/Unit Total : 31.5000 sf(s)

Pick:

Qty Part Number Description Batch

30 sf M304EX0.75-16F Expanded Metal M100513

PD

06-04-11

12.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner JigDeburr as required

A/R SS ROD Batch: M19555

PD

06-04-11

13.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

11 06/04/11

14.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/04/13 ①

15.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06/04/13 ①

16.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

N/A

17.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/04/20 ①

Job Completion



✓ 06/04/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5/04

DART AEROSPACE LTD		Work Order:	22087
Description: 206B Basket Base		Part Number:	D2330-041
D1 Drawing: D2330 Rev. D Pages 1,3,4 & 5		Qty:	1

P04.0123

Step	Location	Procedure	By	Date	Qty
1	DC	Open Traveller Dwg not required	RF	04.12.14	1
2	WS	Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: _____ Cut Qty. 4 D2235-1 from: Qty. 4 D3166-1 Batch: _____			
3	WS	Drill hole in D2330-3 as per Dwg D2330			
4	WS	Deburr			
5	WS RF 02/09/10	Pick: Qty      Part Number      Description      Batch 2      D2253-1      Gusset 1      D2012-107      Clevis 1      D2327-3      Bushing 4      D2581      Mounting Chanel 2      D2254      Lug 30 sf      M304EX0.75-16F Expanded Metal			
6	WS	Weld as per Dwg D2330 using Welding Table and corner Jig Deburr as required			
7	QC9 & 6	Inspect Welding and Dimensions			
8	WS	Take Traveller D206-540-013 to KP			
9	FP	Powder Coat White (Ref. 4.3.5.2) as per QSI 005 4.3			
10	QC3	Inspect Powder Coat			
11	FP	To Miscellaneous Cell for Assembly			

Rev	Date	Change	Revised By	Approved
B	94.12.03	/		JB
C	99.09.17	Re-format (was Ipp-341B)	EC	
D	99.12.14	Re-format, Added Clevis to pick list	EC	
E	00.02.03	Re-format, Added Rib to pick list	EC	
F	00.06.26	Removed P/O for powder coat	EC	
G	02.07.23	Re-format added D3166-1; Modify Step 1	KJ	
H	02.09.04	M304EX0.75-16F was M750-16FXS-S/S	KJ RF	RF

RELEASED  
02/09/09 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_